

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-012869**Date Inspected:** 18-Mar-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Liu Hua Jie**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Shailesh Wadkar was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

Bay 14:

This QA Inspector observed the following work in progress:

Flux Cored Arc Welding (FCAW) of weld joint SEG3005\*-002 (for 12BW). Welder was identified as 201215. ZPMC Quality Control (QC) is identified as Liming Yang. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2231-B-U2-F.

Submerged Arc Welding (SAW) of weld joint SEG3003\* - 003 (for 12 CE). Welder was identified as 044771. ZPMC Quality Control (QC) is identified as Liming Yang. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2221-B-L2C-S2.

Outside Yard:

CB10.

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## WELDING INSPECTION REPORT

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This QA Inspector observed ABF Personnel, identified as Mr. Cao Hui Zhao, marking areas to be repaired on weld no: CB202A-010 - 017. This weld has been rejected by Contractors UT Personnel. This QA Inspector verified the locations marked for repair as per UT report no: UT-CB10-001 & Critical Weld Repair Report (CWR) No: B-CWR999 Rev-0, Dt: 12/31/09.

No other significant work was being performed on this CB at the time when this QA was present.

CB8:

Notification No: 005368.

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector has generated MT report for this date. The member(s) are identified as OBG components. The weld designations reviewed are as follows:

- 1) FB204-017 – 071, 072, 077 to 080, 085, 086, 007, 008, 016, 017, 026, 029, 044, 047.
- 2) FB204-018 – 071, 072, 077 to 080, 085, 086, 007, 008, 016, 017, 026, 029, 044, 047.
- 3) FB204-019 – 071, 072, 077 to 080, 085, 086, 007, 008, 016, 017, 026, 029, 044, 047.
- 4) FB204-020 – 071, 072, 077 to 080, 085, 086, 007, 008, 016, 017, 026, 029, 044, 047.
- 5) SP205A-008 – 015 to 018.
- 6) SP206A-008 – 009 to 014.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang; phone: 15000422372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Wadkar,Sailesh	Quality Assurance Inspector
<b>Reviewed By:</b>	Hall,Steven	QA Reviewer

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